

Date: Tuesday, 01/04/2008 3:47:49 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS KIT	
Job Number :	38285			
Estimate Number :	12866			
P.O. Number :		Part Number :	D412702043B	
This Issue :	01/04/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	IIN D412-702 REV E	
First Issue :	/ /	Project Number :	N/A	
Previous Run :	38078	Drawing Revision :	E	
	Type :	Material :		
	SMALL / MED FAB	Due Date :	21/04/2008	Qty: 4 Um: Each
Written By :				
Checked & Approved By :	JD 08.4.01			
Comment :	est rev A 07.05.10 new issue EC est rev C 07.06.20 changed AN44 4A to AN444A EC Est Rev:D 07-07-06 As per Rev E JLM Est Rev:E 08-03-31 now at chg003 ECN1150 DD verified by:			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-702-043B CHG003

08/04/12 08/4/18 JLD

2.0	D412702059	GROMMET KIT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

GROMMET KIT

batch: 37355 (1x) 38302 SP

3.0	D412702101B	HARNESS ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

HARNESS ASSEMBLY

batch: 38303 SP

4.0	D412702103B	HARNESS ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

HARNESS ASSEMBLY

batch: 38304 SP

5.0	D412702105B	HARNESS ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

HARNESS ASSEMBLY

batch: 38305 8/4/9 SP (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:47:49 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS
KIT

Job Number: 38285

Part Number: D412702043B

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D412702107B	HARNESS ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

HARNESS ASSEMBLY

batch: 1338306

SC

7.0	D412702109B	HARNESS ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

HARNESS ASSEMBLY

batch: 38307

SC

8.0	D35421	BRACKET
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BRACKET

batch: 1334221 (1x)

* 38296 (7x)

SC

9.0	D35711	GUIDE
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

GUIDE

batch: 1338086

SC

10.0	D35713	GUIDE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

GUIDE

batch: 1331869

SC

11.0	D3578041	DOUBLER
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

DOUBLER

batch: 1337309

SC

12.0	D3610041	BRACKET
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BRACKET

batch: 38087 x4

8/4/21
38301 (4x)

8/4/9 SC (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:47:49 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS
KIT

Job Number: 38285

Part Number: D412702043B

Job Number:



Seq. #:	Machine Or Operation:	Description :
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#13.0	D36181	CAP
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

CAP

batch: 1332426

SP

#14.0	AN410A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch: M105442

SP

#15.0	AN444A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

bolt

batch: M104806

SP

#16.0	MS24693S274	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M104214

SP

#17.0	MS24694S56	SCREW
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

SCREW

batch: M104407

SP

#18.0	MS24694S58	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: M11735

SP

#19.0	MS24694S60	Screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: 11760

8/4/9

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 01/04/2008 3:47:49 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS
KIT

Job Number: 38285

Part Number: D412702043B

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0 AN960JD416 Washer

Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

batch: M106780

500

21.0 AN960JD416L Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

batch: M107008

500

22.0 MS21042L4 Nut

Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Nut

batch: M106825

500

23.0 CR321244 -409 Cherry Rivet

Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Cherry Rivet

batch: M107008

M107428

8/4/9

50

44

24.0 QC4 INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/12/44

25.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-043B CHG003

Location:

PPP Rev: C

8/4/21

34

4x

26.0 QC21 FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

08/04/23

Job Completion



mf 08-04-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1	1			1	D412-702-105B	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-046	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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WORK ORDER

Revision: E
Date: 07.06.27

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1			1		D412-702-115B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-046	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1			1		D412-702-117B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-045	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: E

Date: 07.06.27